ABET LAMINATI TECHNICAL DATA
TEFOR
R0712

Manufacturer

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PRODUCT DESCRIPTION

Basic Use: Tefor is a decorative surface made from recycled materials. It is not a high pressure laminate. Instead, it is a thermoplastic. Tefor applications include any decorative surface with low abrasion activity.
Composition: Tefor is a composite material made from polypropylene and HPDL dust (obtained from milled HPDL plastic laminates produced according to EN 438 Standard). It can be either extruded or calendared.
Limitations: Tefor does not have the abrasion resistance of HPDL but it does have higher impact strength. Light duty applications only. It cannot be produced with the same color consistency as HPDL given the recycled nature of its composition. Tonal consistency only exists within each production batch. Further, it must be bonded with contact adhesive not a rigid glue line. Tefor is not intended to be used for exterior applications. It is not a structural material and is to be bonded to a suitable substrate. Do not use in areas with temperatures higher than 275 degrees F (135 degrees C) for extended periods of time. This product is not to be exposed to continuous, direct sunlight.
Surface Protection:
Because the surface of Tefor is similar in scratch resistance to raw wood we offer the following advice for surface protection. Much like raw wood, protection of the surface can be aided with a clear spray coating to help reduce scratches. Different finishes offer different solutions. For example, waterborne materials may hold up to cleaning better than solvent borne materials. Solvent borne finishes will likely offer better adhesion, however. Coating the surface will not affect Tefor's waterproof characteristic. For waterborne options ABET Inc. has had success with Mohawk's waterborne pre catalyzed lacquer m640 series and the waterborne conversion varnish m641 series products. For a solvent borne lacquer option we offer Mohawk m612 series as a solution. All of these options are Greenguard certified. Preparation for the finish spraying operation is best done with a medium or coarse nylon pad. Sandpaper, steel wool or micron paper will offer disappointing results. All Mohawk products are available through MacMurray Pacific Wholesale Hardware (415.552.5500) or other authorized Mohawk distributors. Inasmuch as spraying techniques, humidity levels, temperature and other factors can greatly affect the results, these guidelines cannot guarantee results. Consultation with an ABET Inc. representative is advised.
Colors: Tefor is stocked in 7 colors as of 2006. Other colors may be available as a custom order.
Sheet Size: 51" (130 mm) x 120" (305 mm)
Thickness: 0.059" (1.5 mm)

FABRICATION AND ASSEMBLY

Tefor should be bonded to suitable substrates such as particleboard and medium density fiberboard (MDF) with suitable contact adhesives. Please avoid rigid glue lines such as PVA or aliphatic. Please avoid hot presses similar to those used for veneers. Use contact adhesive similar to those available for other high pressure plastic laminates. The choice of adhesives is based upon the service for which the assembly is intended and the bonding facilities available. In all cases, the adhesive manufacturer's instructions for use should be followed closely. Backer sheets are recommended for use on the back of the panel-assemblies to protect the substrate from humidity changes and reduce warpage.

All Tefor sheets are to be inspected prior to lamination to ensure they are sound, clean, and free of surface defects. All cutouts should be routed or filed to ensure smooth edges. A radius of 3.175 mm (1/8") or larger in the corners is recommended to minimize stress cracking.
Drill oversize holes (at least 0.05 mm or 0.002" larger in diameter) for screws and bolts.
Material, equipment, and workmanship should conform to industry standard practices, conditions, procedures, and recommendations as specified by ANSI/NEMA LD-3-2005 Standard for High Pressure Decorative Laminates, Annex A, Application, Fabrication, and Installation; or Architectural Woodworking Institute (AWI) "Architectural Woodwork Quality Standards, Guide Specifications and Quality Certification Program".

TECHNICAL DATA

Physical State	20 Degrees C solid
Appearance	Various colors of sheets
Specific Weight	20 Degrees C: 1000+/- 50 Kg/cubed meter
Melting Point	160 Degrees C
Solubility	Insoluble in water or acid and base solutions; soluble at high temperatures in aromatic solvents especially in chlorinated ones.
Air Stability	Stable

FIRE TEST DATA

Tefor is a combustible product.
Self ignition temperature – 400 Degrees C
Flammability temperature – 300 Degrees C
Combustion products – on ignition the product burns with a flame developing H_2O and CO_2 and in the absence of oxygen also CO. The combustion products are toxic and irritating.
Decomposition products – During the initial stages of burning (particularly between 400 and 700 degrees C) other types of product such as hydrocarbons, ketons and aldehydes can form.
Extinguishing methods – Atomized water, alcohol resistant foam, chemical powder, carbon dioxide.
Precautions in the event of fire – Use anti gas mask with universal filter and in more serious cases, breathing apparatus.
First aid – In the event of inhalation of smoke as a result of combustion, it is necessary to remove the person from the polluted area as quick as possible. If needed, artificial respiration must be administered and a doctor has to be called. In the event some melted Tefor drips onto skin or clothes wash immediately with cold water and seek medical assistance.

TOXICITY

The compound is chemically non reactive and biologically inert. The polymer and the HPDL dust are inert upon contact with foodstuffs. Additives and pigments are considered inert and approved for food packaging in all countries having regulation for such use.

Inhalation – At room temperature there are no emissions which could prove to be harmful. At higher temperatures a characteristic smell may develop but without any consequences to human health.

Ingestion – Although the components of the product are inert, swallowing the product can induce collateral problems.

STORAGE

The product remains stable under normal storage conditions. The usual packaging is on wooden pallets. Keep protected from the sun and far from sources of heat. Avoid smoking, exposed flame and electrical charges. Leave the product in ventilated areas.

The material is insoluble in water, chemically inert and gives off no polluting effects. All waste which cannot be otherwise used in a recycling process may be disposed following normal procedures regarding industrial waste.

TECHNICAL SERVICE

For samples, literature, and technical assistance, call our toll-free line 800-228-2238 from 8:30 AM to 5 PM, East Coast Time, Monday thru Friday, or visit our web site www.abetlaminati.com.

The above information is based on the current state of technical knowledge, but does not constitute any form of guarantee. It is the personal responsibility of users of the product described in this information leaflet to comply with the appropriate laws and regulations.